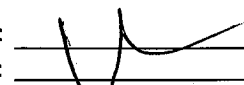
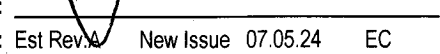


Date: Tuesday, 02/10/2007 12:53:40 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 34964	
Estimate Number : 12578	
P.O. Number : N/A	Part Number : D3560041
This Issue : 02/10/2007 S.O. No. : N/A	Drawing Number : D3560 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34474	Material : H/A
Written By : 	Due Date : 09/10/2007 Qty: 5 Um: Each
Checked & Approved By : 	
Comment : Est Rev. New Issue 07.05.24 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
PULL FROM STOCK:

2.0	D3560041	ARM WELDMENT
-----	----------	--------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
ARM WELDMENT
B 32643 = 5 ~~3 34477 = 2~~
B 32643 = 5 ~~3 34477 = 2~~

3.0	D35921	PLATE
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
PLATE 3 34478 = 3 3 34260 = 2

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

Date: Tuesday, 02/10/2007 12:53:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34964

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 07-10-03 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 07-10-03 (5) (710)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BE

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LE 07-10-03 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

LE 07-10-03 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

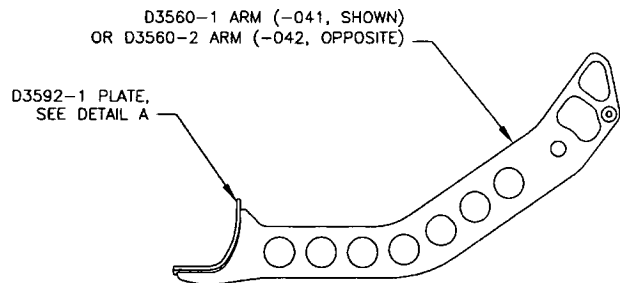
(5) 07-10-04

Job Completion

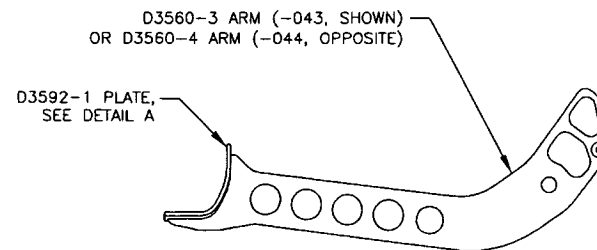


W 07-10-04

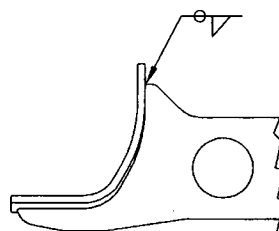
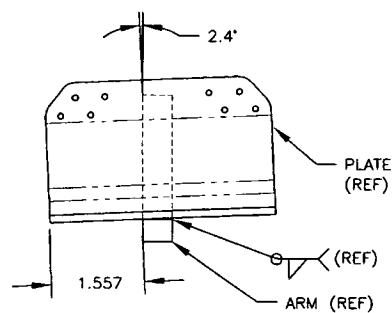
19964
D3560



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

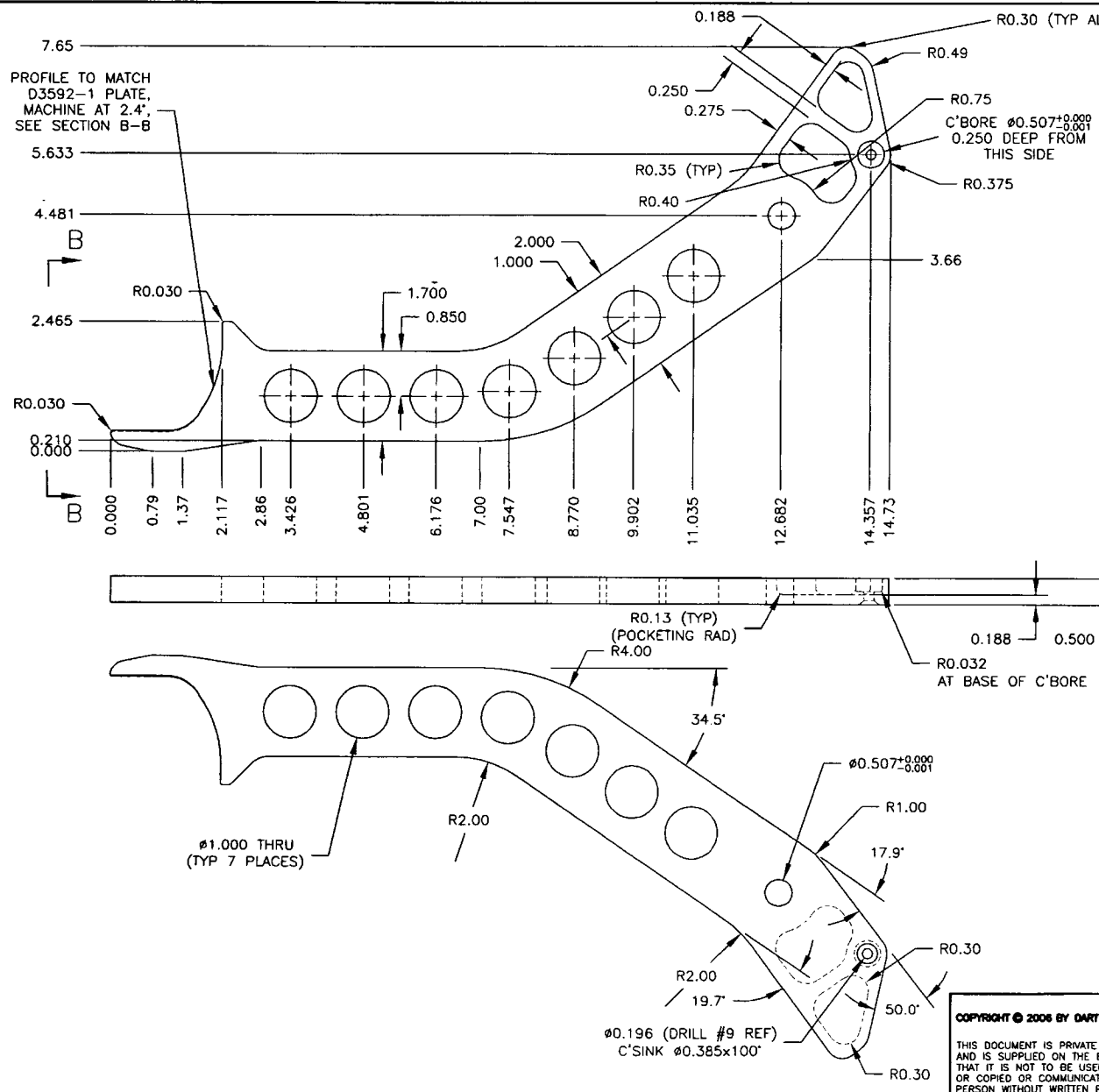
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	q	DRAWN BY q
CHECKED	#	APPROVED #
DATE	07.06.19	TITLE
		ARM WELDMENT
		SCALE 1:4

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

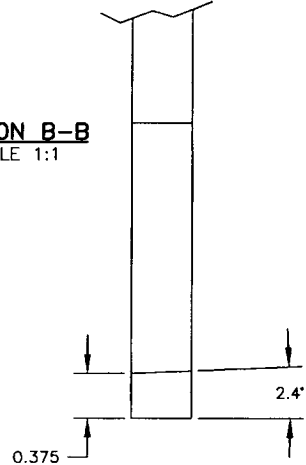
DRAWING NO. D3560 REV. C
SHEET 1 OF 3



D3560-1 ARM (SHOWN). D3560-2 ARM (OPPOSITE)

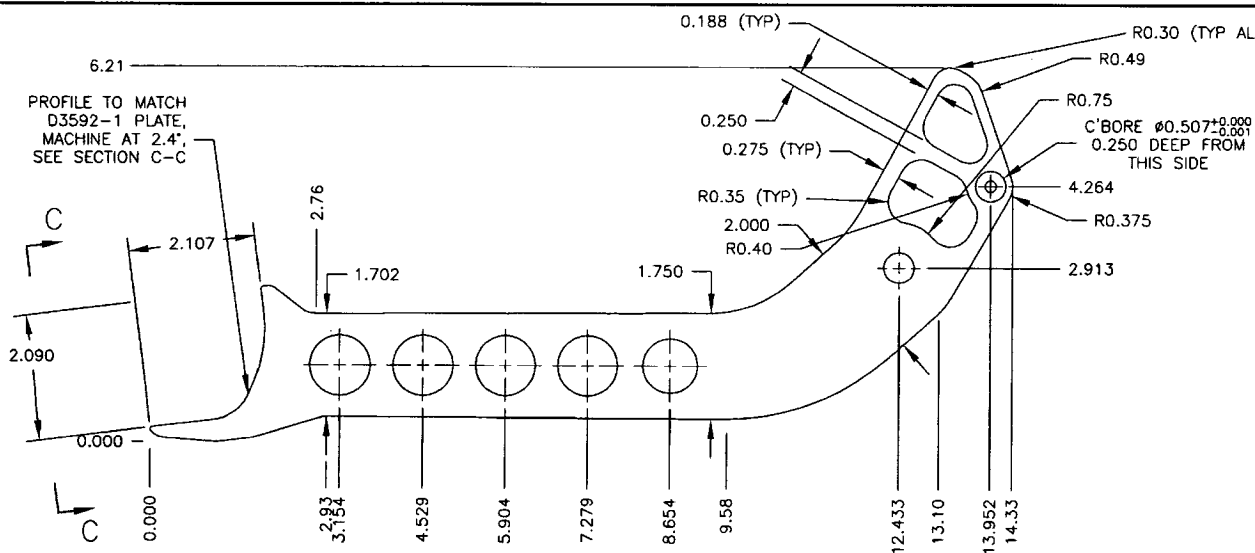
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1



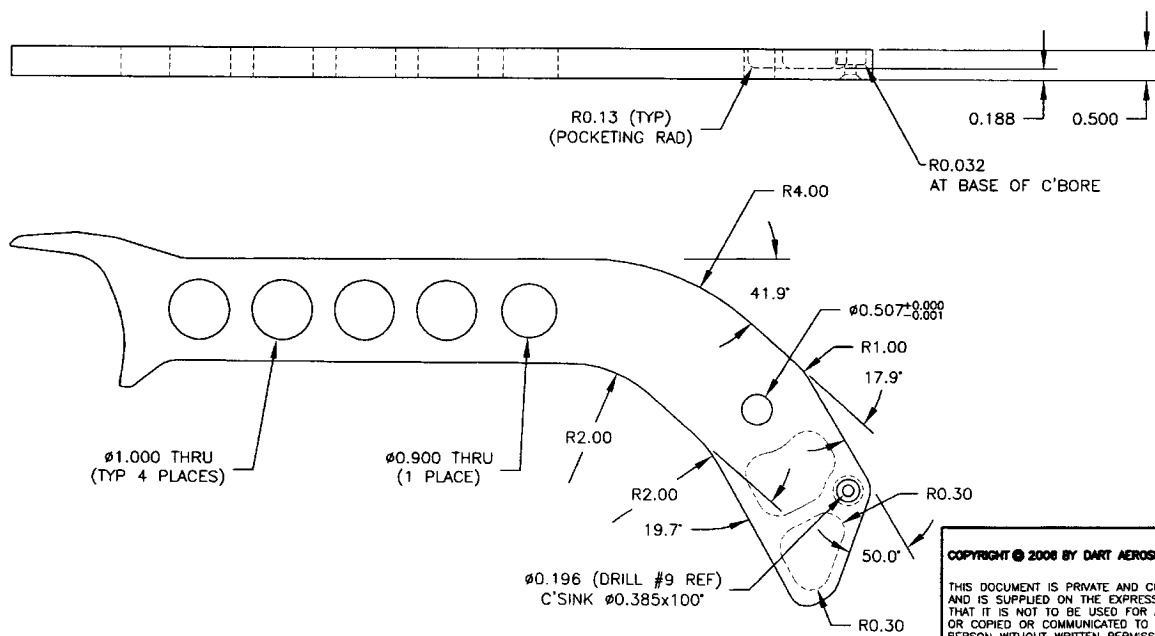
RELEASED
07.06.29

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DATE 07.06.19		TITLE ARM WELDMENT			SHEET 2 OF 3 SCALE 1:2

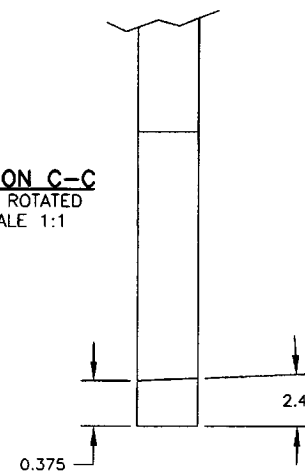


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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07.06.19

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APPROVED

DRAWING NO.

REV. C

DATE

TITLE

SCALE

07.06.19

ARM WELDMENT

1:2